

13/11
Work Order ID 53681

November 12, 2009 8:50:26 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4015-1

Accept



Setup Start



Revision ID:

Item Name: Wearbar

Stop



Start Date: 11/12/09 Start Qty: 5.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4015

A-PRELIM

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4015

Dwg Rev: *PRE*
Prog Rev: *Lim*

2-Deburr if necessary

1B 9-11-12

(15)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1B 9-11-12

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Page 2

Item ID: D4015-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearbar

Start Date: 11/12/09 Start Qty: 5.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>09.11.12</i>	<i>(15x)</i>					
130 Brake NC Brake NC	Form as per dwg Memo ***Use DT9541 forming tool***	0.00 0.00							
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

09/11/12

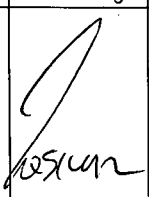


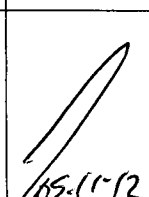
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14

09.11.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4015-1 PAR #: D4015-1 Fault Category: small Pab/W.S NCR: Yes No DQA: Yes Date: 09-11-24
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 08-11-24

NCR: 53681		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/11/12	130	1 piece was lost Scrap when press part moved K-C process		Scrap + destroy no replace	SB 09/11/12			

NOTE: Date & initial all entries

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Item ID: D4015-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearbar

Start Date: 11/12/09 Start Qty: 5.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>WE</u>	0.00							
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

SP 09 11 13

14X

ENG

POSITIVE RECALL

EFFECTIVE 11.11.09 AUTH h

RELEASED _____ DATE _____

11.09.11.19

R00324ANOV

Picklist Print

November 12, 2009 8:50:25 AM

Page 1

Work Order ID: 53681



Parent Item: D4015-1



Parent Item Name: Wearbar

Start Date: 11/12/09

Required Date: 11/13/09

Comments: IPP RevA: New issue 09.10.28 verified by:JLM
remove welding 09.11.03 DD verified by:EC

IPP Revb:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	201.3664	0.0500	.15		



304/316 Sheet .063



DB 9-11-12

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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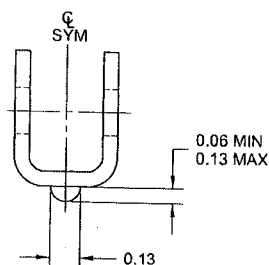
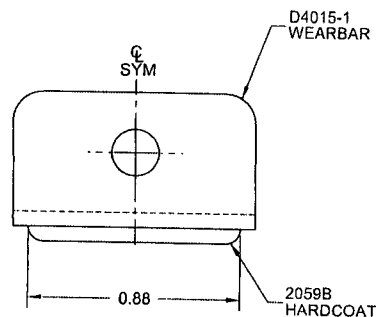
Main Warehouse

MAT	201.3663737	
106860	16.018	
111924	25.1689737	
112442	32.0821	
112567	0.2973	
112885	127.8	

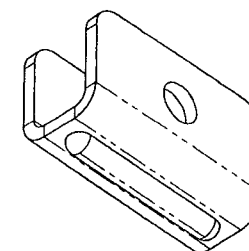
112442

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ITEM	QTY	P/N	DESCRIPTION
1	1	D4015-041	WEARBAR
11	1	D4015-1	WEARBAR
21	A/R	2059B	HARDCOAT



WLB 53681



D4015-041 WEARBAR WELDMENT

PRELIMINARY ISSUE

NOTES:

- 1) MATERIAL: SEE SHEET 2 FOR D4015-1
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs
- 8) WELDING: PER DART QSI 004

P1	NEW ISSUE	MB	09.10.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.10.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4015

REV. P1

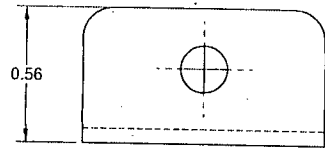
SHEET 1 OF 2

TITLE
WEARBAR WELDMENT

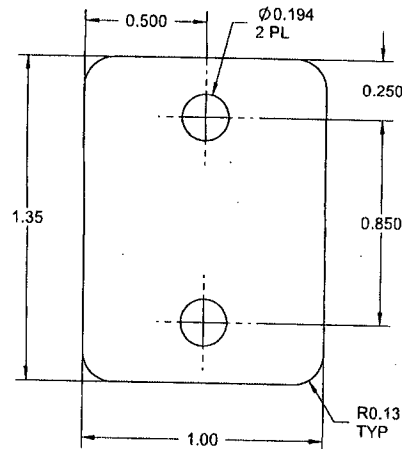
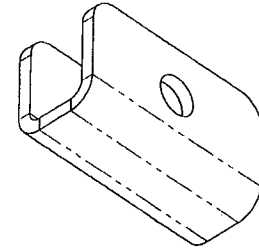
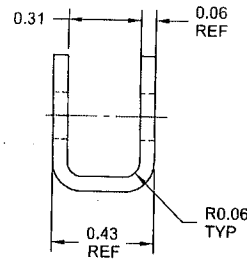
SCALE

NTS

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D4015-1 WEARBAR
MAKE FROM D4015-1



D4015-1F WEARBAR FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

Handwritten: 53681

PRELIMINARY ISSUE

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. P1
MFG. APPR.		D4015	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARBAR	NTS
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